

Work Order ID 52846

October 15, 2009 12:37:14 PM



Page 1

Item ID:	D2665-2	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	15/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	27/10/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2665	Rev D								

100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Program batch number <input type="checkbox"/> 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet <input type="checkbox"/> 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet <input type="checkbox"/> 4- Machine Step # 3 of Folio and visually inspect as per attached								
110		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120		0.00							
	QC2- Inspect parts off machine FA1/FAIB								
QC	Memo	0.00							
Quality Control									

6 0

mmf 09/12/01

6 0

mmf 09/12/02

6 0

mmf 09/12/01

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Item ID: D2665-2

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 15/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mt 09/12/02			6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BR 09-12-3			6			
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 10:45 320° FINISH TIME: 11:15	0.00 0.00	BR 09-12-3			6			

OVEN TEMPERATURE:

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Item ID:	D2665-2	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	15/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	27/10/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	MU 09/12/03			(X6)	Ø		
170 Packaging Packaging	Identify as per dwg & Stock Location <u>435</u> Memo	0.00 0.00				9/12/3		6050	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						09/12/07	MF 09-12-04

Picklist Print

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Work Order ID: 52846



Parent Item: D2665-2RevD



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003RevB		Manufactured	No			100	Each	0.0000	6.0000			

Saddle Billet, 7075

B 46410 x 6 mnt 09/12/01

DART AEROSPACE LTD	Work Order:	52846
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	5	6
A	0.100	0.140		.110	.111	.111	.111	.110	.111
B	0.100	0.140		.120	.120	.120	.121	.121	.125
C	1.125	1.145		1.136	1.135	1.135	1.136	1.136	1.135
D	0.615	0.685		.678	.680	.678	.680	.675	.680
E	0.240	0.260		.247	.246	.247	.247	.247	.253
F	1.313	1.343		1.340	1.334	1.327	1.333	1.335	1.336
G	0.210	0.230		.222	.223	.222	.222	.222	.222
H	0.100	0.180		.134	.134	.133	.135	.134	.125
I	2.470	2.510		2.490	2.490	2.490	2.493	2.490	2.490
J	1.565	1.585		1.575	1.576	1.576	1.576	1.575	1.576
K	0.235	0.240		.237	.236	.237	.237	.236	.237
L	0.100	0.120		.113	.114	.115	.115	.114	.115
M	0.990	1.010		.994	.997	.997	.995	.993	.994
N	0.510	0.515		.511	.511	.511	.511	.511	.511
O	5.990	6.010		6.003	6.004	6.003	6.003	6.001	6.002
P	1.245	1.255		1.245	1.247	1.247	1.247	1.247	1.247
Q	2.495	2.505		2.500	2.496	2.497	2.498	2.500	2.500
R	0.313	0.318		.314	.314	.314	.314	.314	.314
S	0.315	0.322		.316	.317	.317	.317	.317	.317
T	2.495	2.505		2.499	2.498	2.497	2.498	2.498	2.500
U	1.357	1.367		1.364	1.363	1.364	1.364	1.364	1.364
V	0.787	0.807		.795	.792	.793	.794	.794	.793
W	0.540	0.560		.548	.553	.552	.550	.549	.550
X	1.674	1.684		1.679	1.680	1.679	1.680	1.681	1.680
Y	0.257	0.262		.260	.260	.260	.260	.260	.260
Z	0.912	0.932		.922	.926	.926	.922	.923	.923
AA	0.490	0.510		.498	.497	.498	.495	.495	.497
AB	0.178	0.198		.183	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

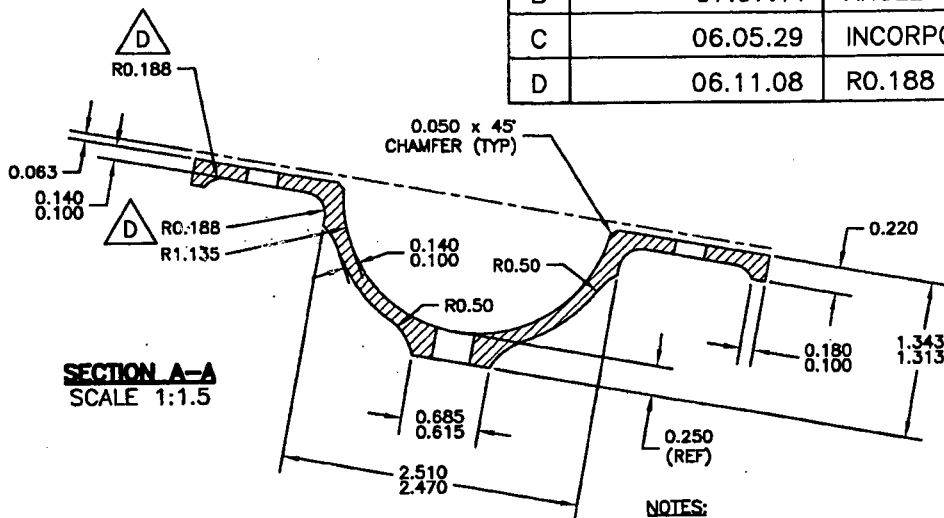
Measured by:	mmf
Date:	09/12/02

Audited by:	mmf
Date:	09/12/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



DESIGN	<i>A</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>A</i>	DRAWING NO.	REV. D
				D2665	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25			NEW ISSUE	
B	97.07.11			ANGLE AND NOTES ADDED	
C	06.05.29			INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08			R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



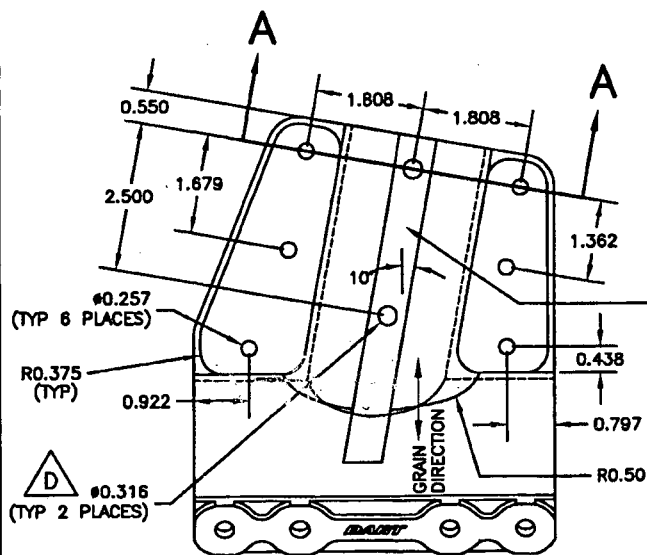
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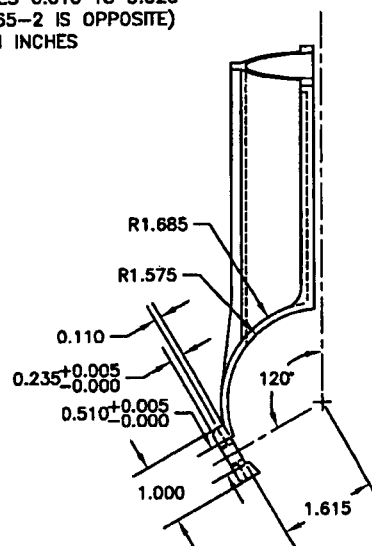
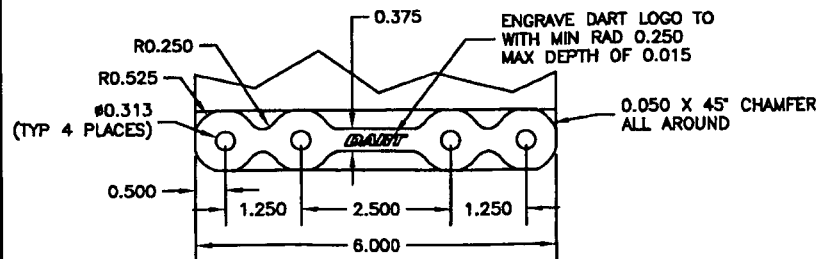
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 52844
RIP 09-10-15

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

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